

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET PRELIM
Job Number	: 31748		
Estimate Number	: 12452		
P.O. Number	: N/A	Part Number	: D119756041
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: IIN-D119-756 PG11-12
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 31583	Material	: N/A
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 06-06-14 JLM		
	: Est Rev. B 06.07.26 dwg revB, picklist EC		
	: est rev C revC dwg 07.04.09 EC		

Job Number:

10 DC DOCUMENT CONTROL

[illegible][illegible]

K2S 07.05.10

Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

20	31748A	BASKET LID ASS'Y (A119)
----	--------	-------------------------

[illegible]

Abstract

Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

ml 07/12/05

3.0	31748B	BASKET BASE ASS'Y (A119)
-----	--------	--------------------------

[illegible][illegible]

Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

ml 07/12/05

40 D2022101 Spacer

Abstract

[illegible]

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch:

B33985

AS 07/12/05

5.0	D2258220	Placard
-----	----------	---------

1. The first group of respondents was composed of 100 randomly selected individuals from the general population of the United States. The second group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The third group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The fourth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The fifth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The sixth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The seventh group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The eighth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The ninth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors. The tenth group was composed of 100 randomly selected individuals from the general population of the United States who were members of the National Aeronautics and Space Administration (NASA) or the National Aeronautics and Space Administration's (NASA) contractors.

[illegible]

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch:_____

B 30810

AS 07/12/05

6.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch:

33467

AS 07/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 33939

AS 07/12/05 (X1)

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: B31486

AS 07/12/05 (X1)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 34788

AS 07/12/05 (X1)

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: B21139

AS 07/12/05 (X1)

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

B29576

AS 07/12/05 (X1)

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104603

AS 07/12/05 (X1)

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 102140

AS 07/12/05 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M102959

AS 07/12/05 (X1)

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M101938

AS 07/12/05 (X1)

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104885

AS 07/12/05 (X1)

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105906

AS 07/12/05 (X1)

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105408

AS 07/12/05 (X1)

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M104156

AS 07/12/05 (X1)

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105057

AS 07/12/05 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M105442

AS 07/12/05 (X1)

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18071

AS 07/12/05 (X1)

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M105558

AS 07/12/05 (X1)

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105054

AS 07/12/05 (X1)

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105430

AS 07/12/05 (X1)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



X1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

mulo 07/12/05

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/12/05 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CLAMP KIT
Batch: 31579

AS 7/12/05 (1)

30.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing B 29991

AS 07/12/05 (1)

31.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer B 31756

AS 07/12/05 (1)

32.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: B 30910

AS 07/12/05 (1)

33.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: B 31628

AS 07/12/05 (1)

34.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: ~~B 31628~~ B 31629

AS 07/12/05 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D35201

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER

29578

AS 07/12/05

(X1)

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M106043

AS 07/12/05

(X1)

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M104746

AS 07/12/05

(X1)

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895

AS 07/12/05

(X1)

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M104156

AS 07/12/05

(X1)

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M105906

AS 07/12/05

(X1)

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer

M105408

AS 07/12/05

(X1)

Batch #

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31748

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

M17619

AS 07/12/05 (X1)

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: M105054

AS 07/12/05 (X1)

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6 7/12/06 (X1)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D119
Location: B
PPP Rev: B

6 7/12/06 (1)

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6 7/12/06 (1)

Job Completion



u 07.12.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

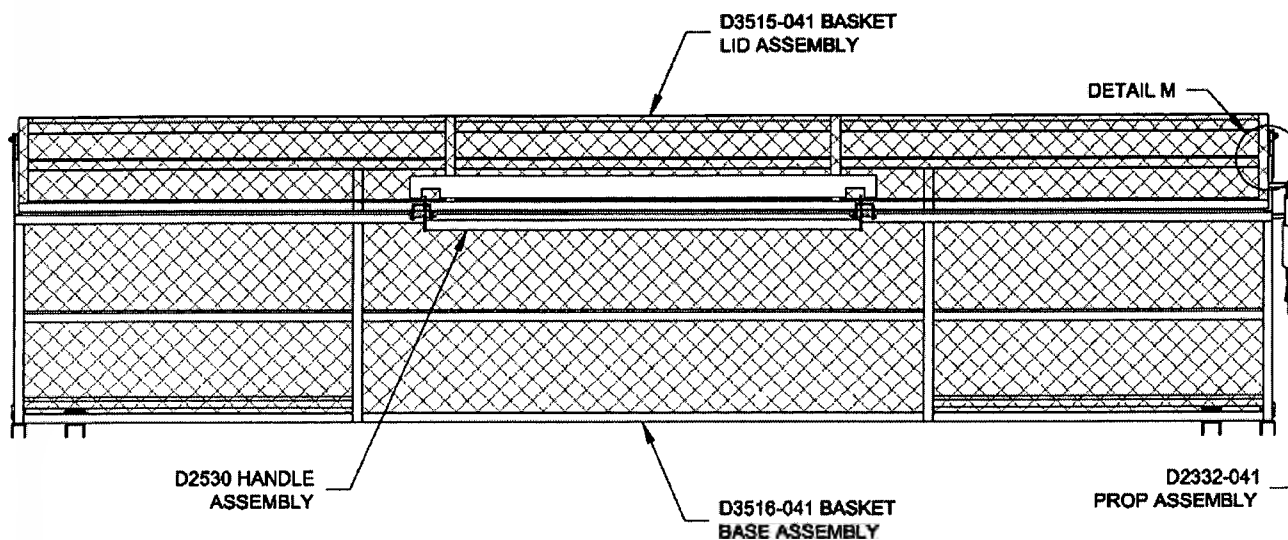
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

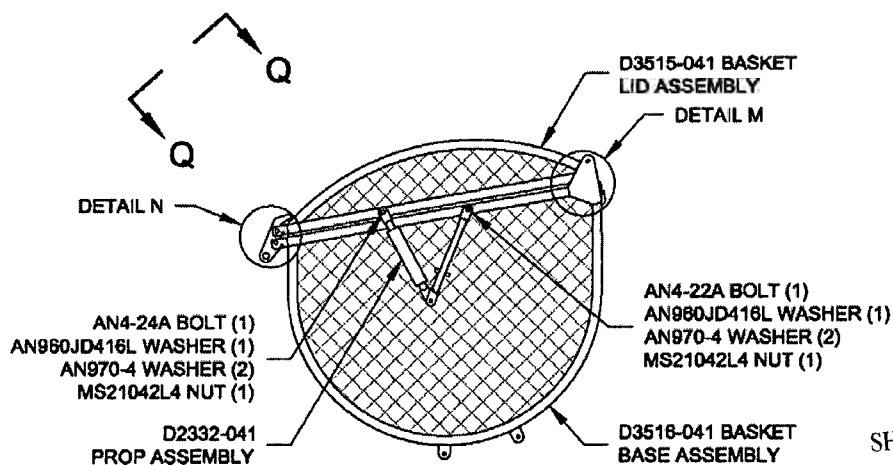
NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart **Heli-Utility-Basket™** which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041
HELI-UTILITY-BASKET**



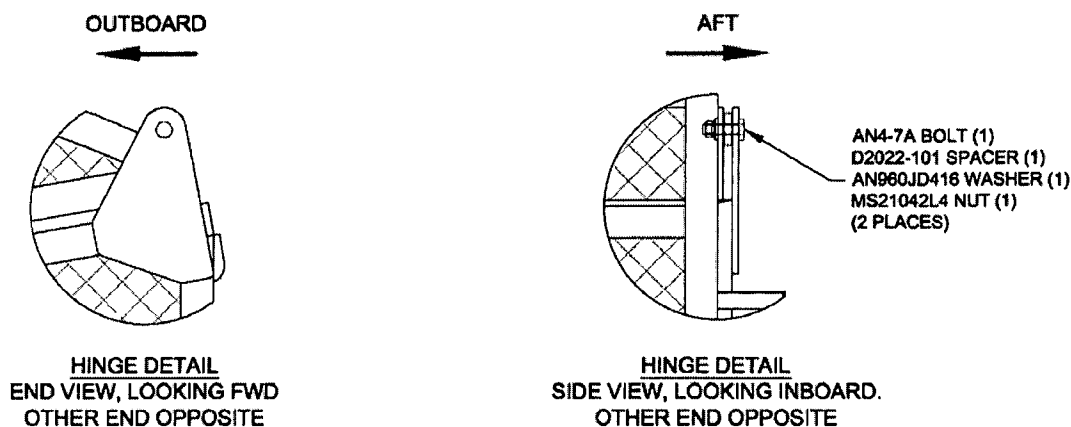
**VIEW C-C:
PROP ARM DETAIL**

**Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)**

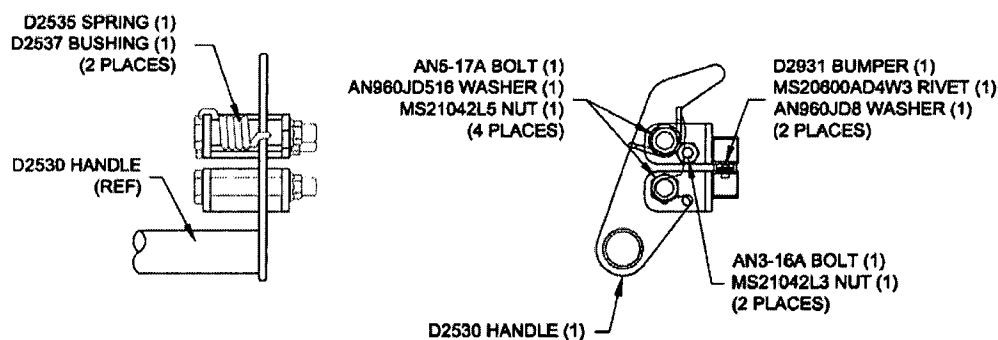
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31748

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Revision: **C**
Date: 06.10.23



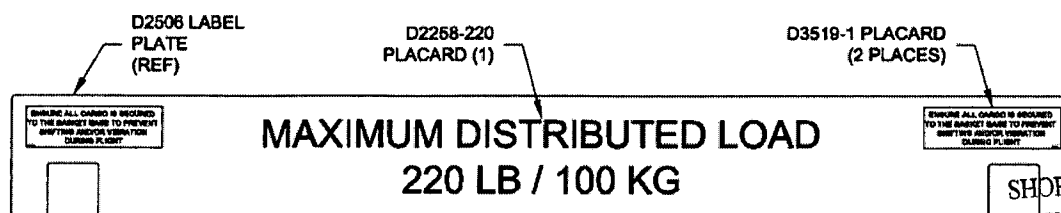
DETAIL M: HINGE



SPRING DETAIL

LATCH DETAIL

DETAIL N: HANDLE WELDMENT



VIEW Q-Q: PLACARDS
ONLY PLACARDS AND
LABEL PLATE SHOWN

Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31748

Date: Thursday, 4/12/2007 8:55:19 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASS'Y (A119)
Job Number	: 31748B		
Estimate Number	: 12431		
P.O. Number	: N/A	Part Number	: D3516041
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D3516 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 31583B	Material	: N/A
	Type : LARGE FAB ASSY	Due Date	: 5/30/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	: <u>407.04.12</u>		
Comment	: EST rev. A 06.05.31 Preliminary EC EST rev. A 06.07.27 updated EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34421	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: 334610 ✓

407.11.27

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: 334507 ✓

407.11.27

3.0	D351611	CLEVIS
-----	---------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLEVIS

batch: 33180 ✓

407.11.27

4.0	D351613	CLEVIS
-----	---------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

CLEVIS

batch: 331627 → 2 331801 → 2 ✓

407.11.27

5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: 3345889 ✓

407.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:55:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31748B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: ~~B10588~~ *

Plot 7-11-27

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: ~~B34423~~ → 1 ~~B35528~~ → 3 ✓

Plot 7-11-27

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: ~~M106199~~ ✓

Plot 7-11-27

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5-Cut rib D3516-9 from D3166-1 (4)

Plot 7-11-27

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

Plot 7-11-27

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Plot 7-11-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:55:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31748B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)
Expanded Metal Flat Stainless steel
Batch: M104218 ✓

Pl 07.11.29

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

Pl 07.11.29

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-30 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-11-30 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M105914

91 07-12-03 (X1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D3515 and QSI 005 4.4 and spay paint as per Dwg
Wing Walk: _____
Black Spray Paint: _____

07/12/03

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mlo 7/12/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:55:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31748B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/12/05

(C)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 07/12/06

Job Completion



U 07/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

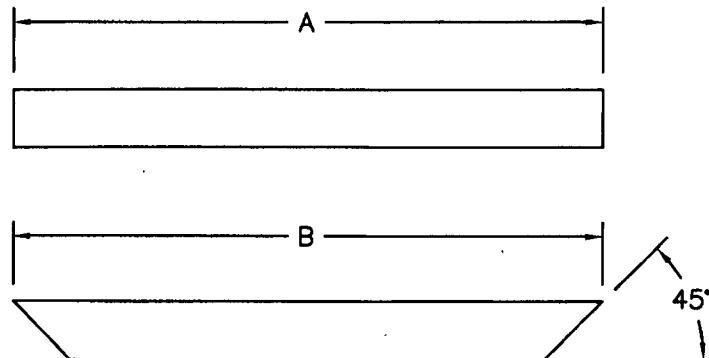
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

RELEASED

06.11.28 *PH***PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B {

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

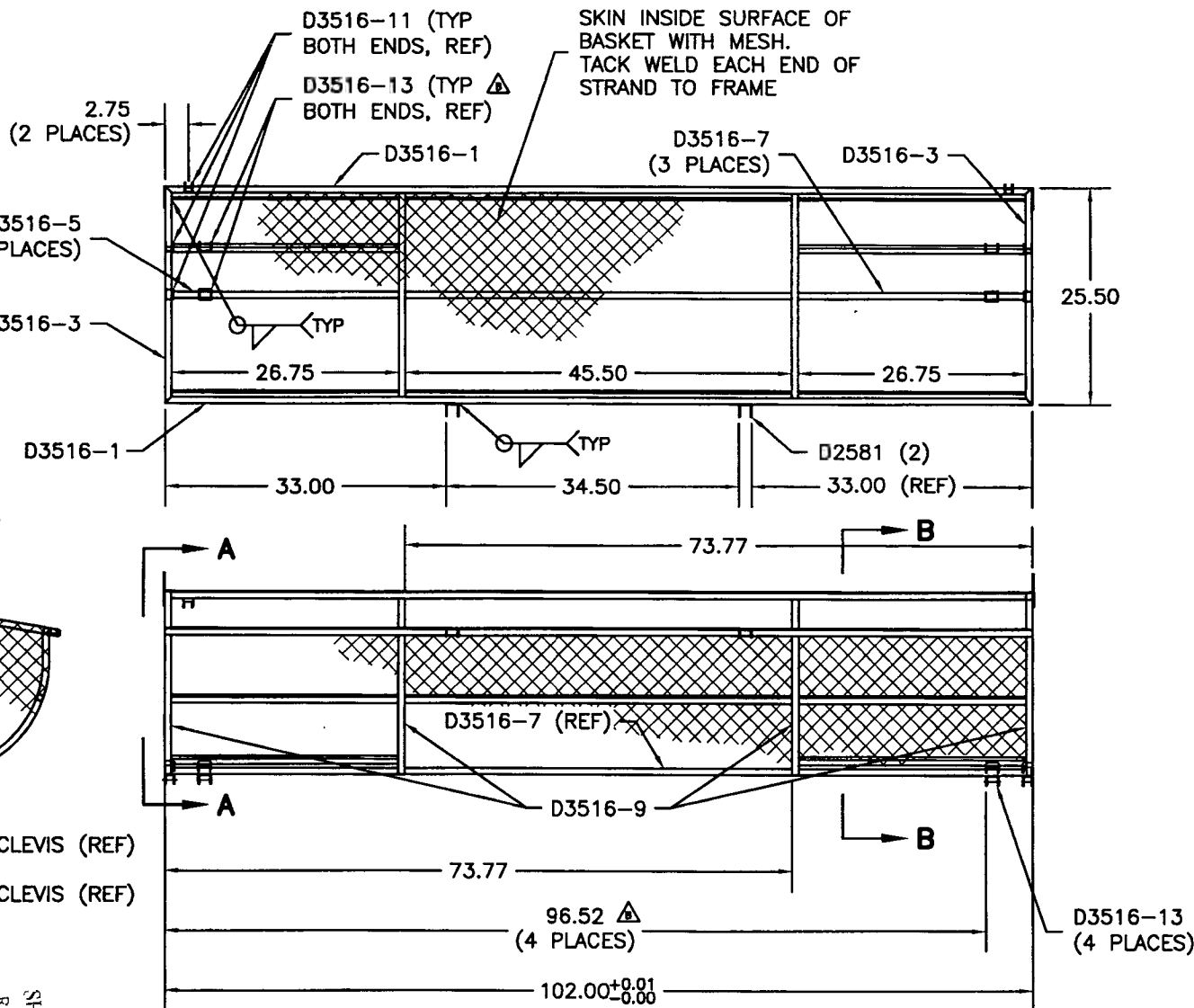
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WORK ORDER
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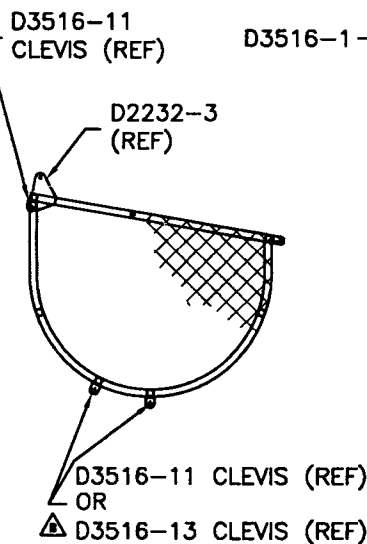
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DATE	TITLE	REV. B
06.07.25	BASKET BASE ASSEMBLY (A119)	SHEET 2 OF 5
		SCALE
		1:20



D3516-041 BASKET BASE ASSEMBLY

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06.11.28

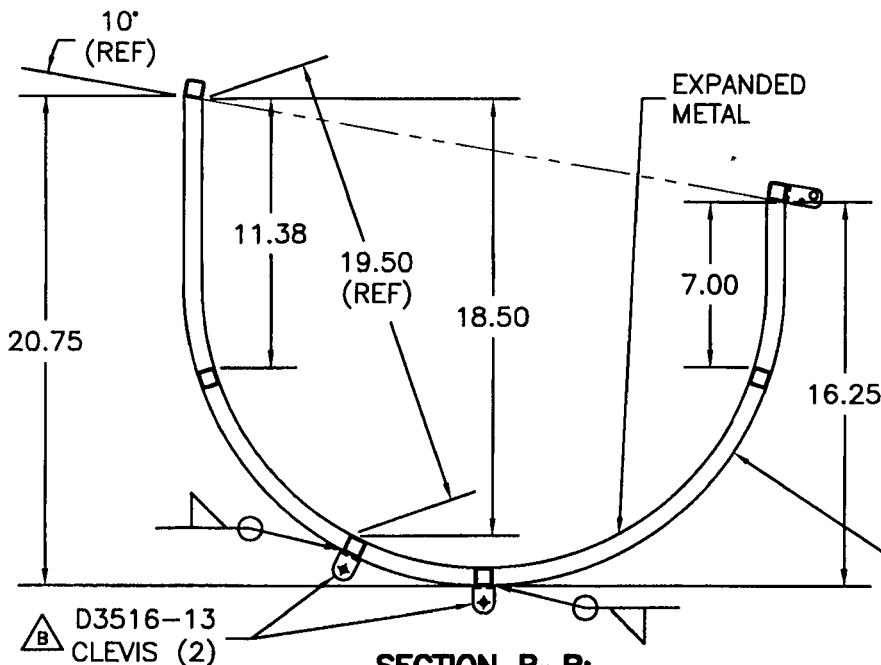
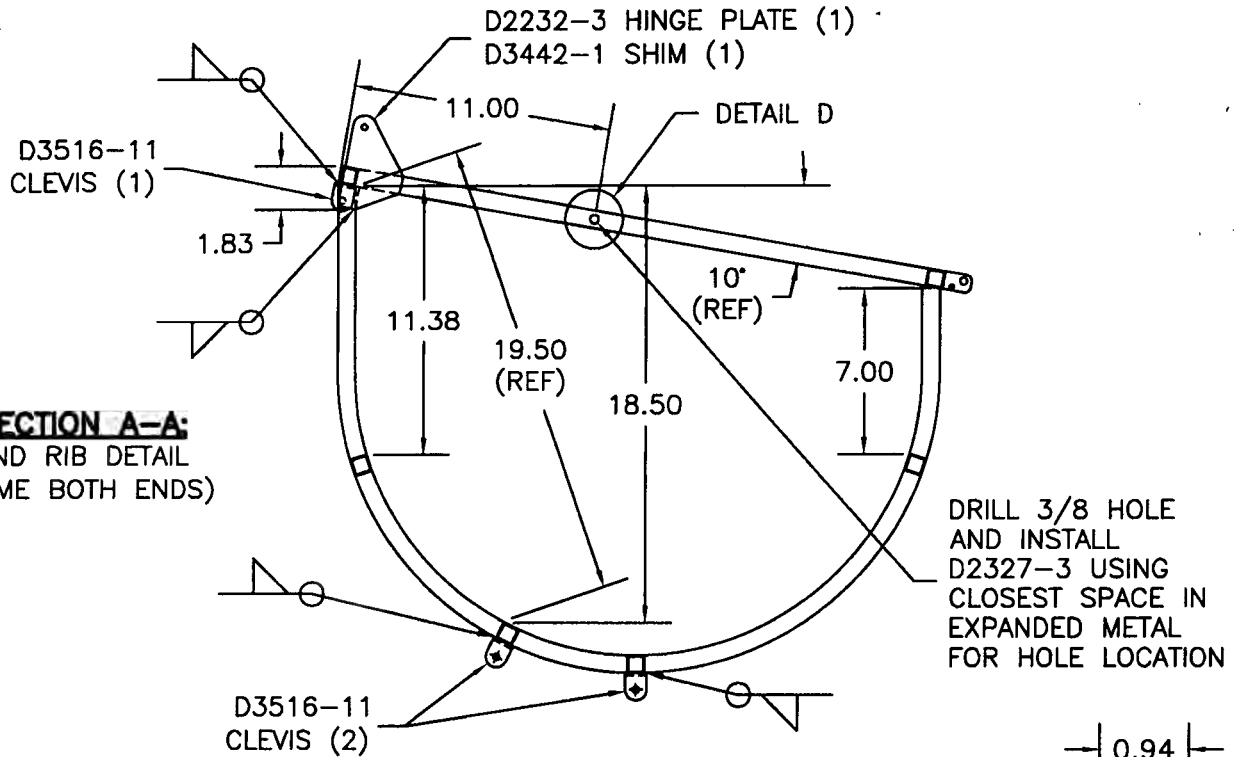


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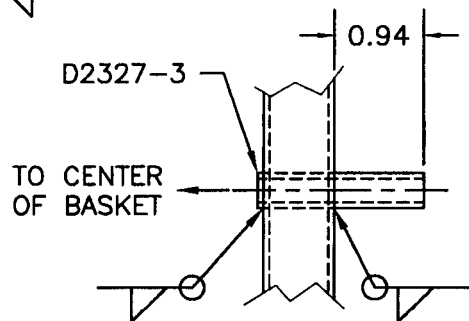
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8

SECTION A-A:
END RIB DETAIL
(SAME BOTH ENDS)



SECTION B-B:
CENTER RIB DETAIL
(2 PLACES)



DETAIL D

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06.11.28
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D3516-9 RIB
(MAKE FROM D2235-3)

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WITHOUT NOTICE

WORK ORDER

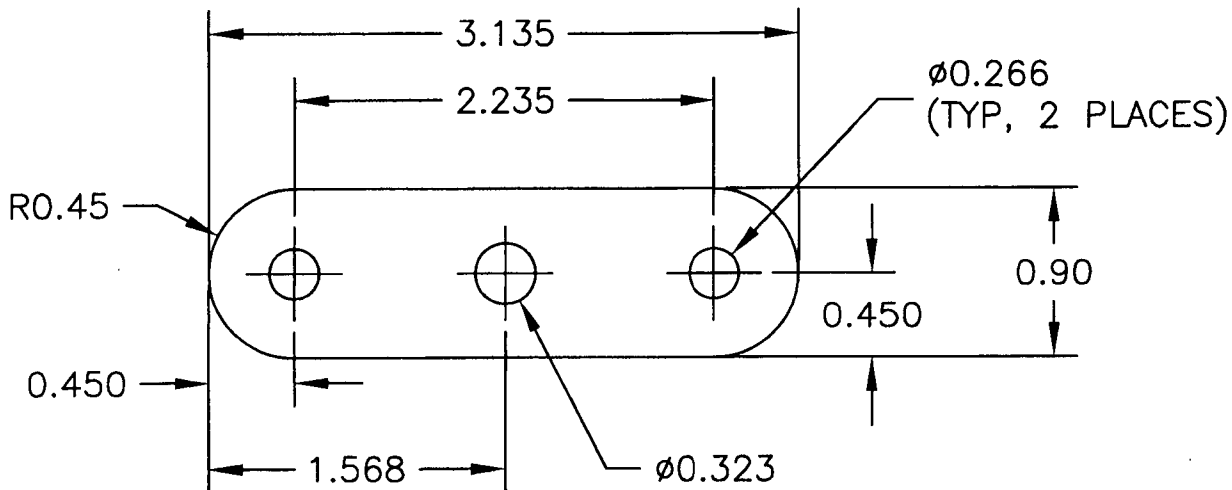
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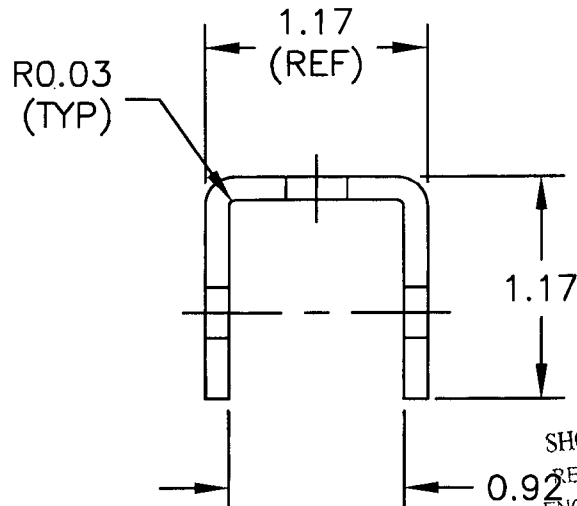
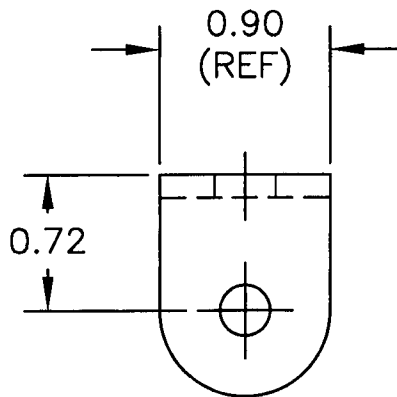
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1

**D3516-11F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

RELEASED

06.11.28 *[Signature]***D3516-11 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

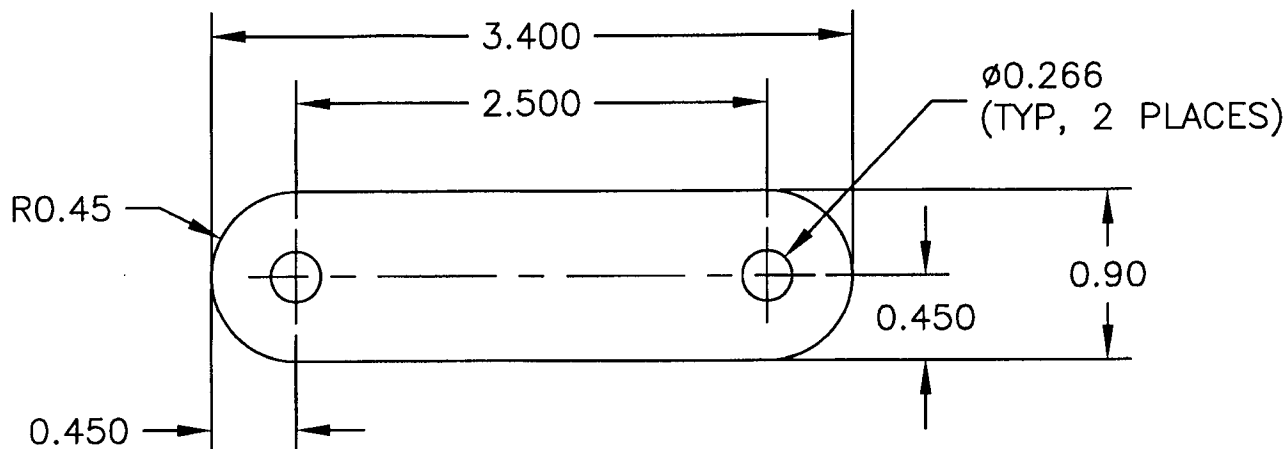
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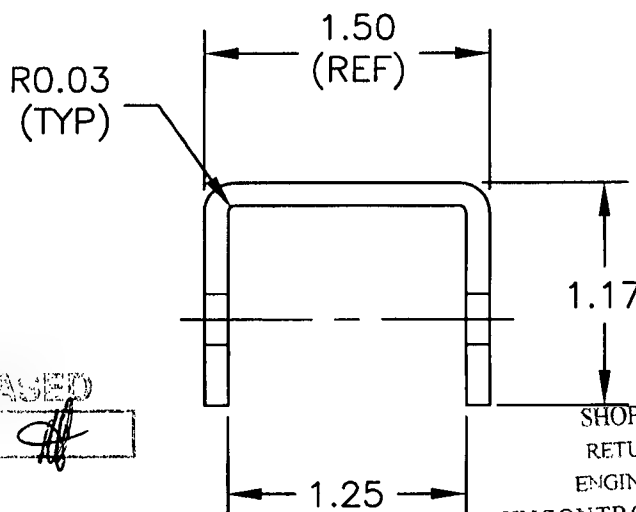
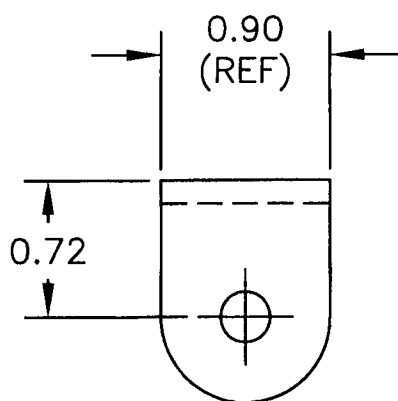


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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3516	REV. B SHEET 5 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



RELEASED

06.11.28

D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 4/12/2007 8:54:59 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASS'Y (A119)
Job Number : 31748A	
Estimate Number : 12445	
P.O. Number : <i>N/A</i>	Part Number : D3515041
This Issue : 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3515 REVA
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>NA</i> Type : LARGE FAB ASSY	Drawing Revision : <i>A</i>
Previous Run : 31583A	Material : <i>N/A</i>
Written By : _____	Due Date : 5/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>9/07.04.12</i>	
Comment : EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	D22321	Hinge
----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: *331608* ✓*Pl 07.11.27*

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: *335529* ✓*Pl 07.11.27*

3.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: *331693* ✓*Pl 07.11.27*

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *333449* ✓*Pl 07.11.27*

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: *334507* ✓*Pl 07.11.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31748A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M106199 ✓

Ppl 07.11.27

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

Ppl 07.11.27 ✓

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

Ppl 07.11.27

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/6/27 (u)

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M104218 ✓

Ppl 07.11.29

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

Ppl 07.11.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:54:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31748A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-30 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-11-30 (1)

14.0

POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

11

07-12-03

(1)

(PT)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/12/05

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m 07/12/05

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07/12/06

Job Completion



U 07-12-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/12/03	14.1	Wing Walk: <u>m/05030</u> Spray paint Black: <u>m/05028</u> <i>permanent change</i>	<i>Ref. 07/12/04</i> <i>①</i>	07/12/03			<i>C</i> <i>07/12/05</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

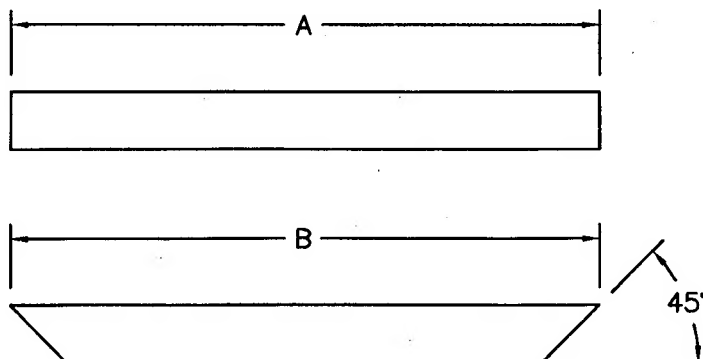
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CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 H

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 31748 A

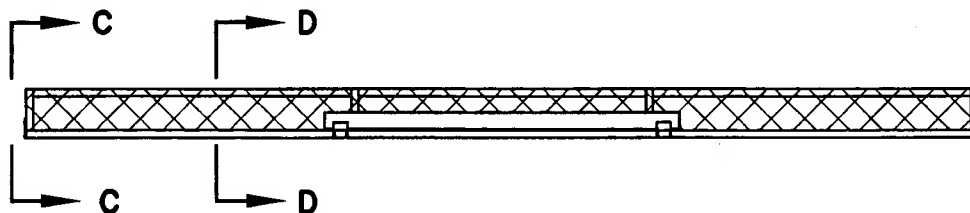
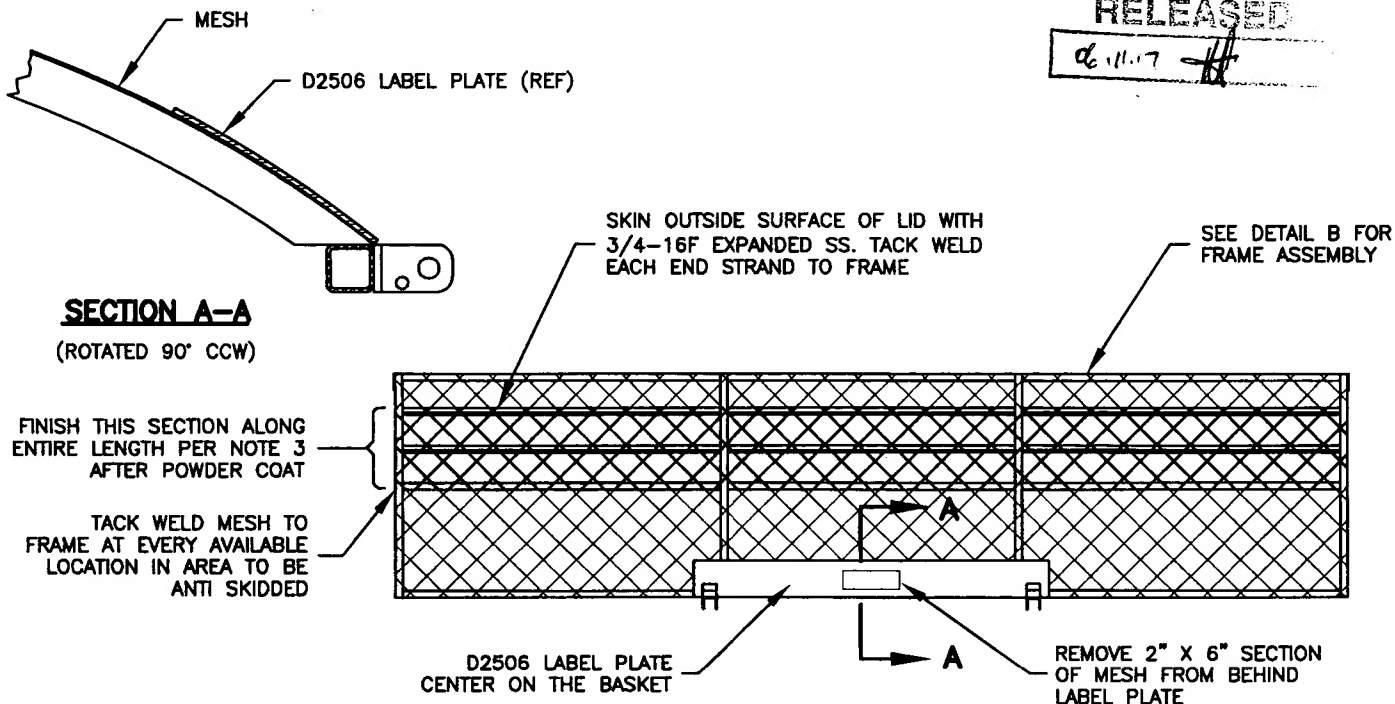
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DART

RELEASED

06.11.17



D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



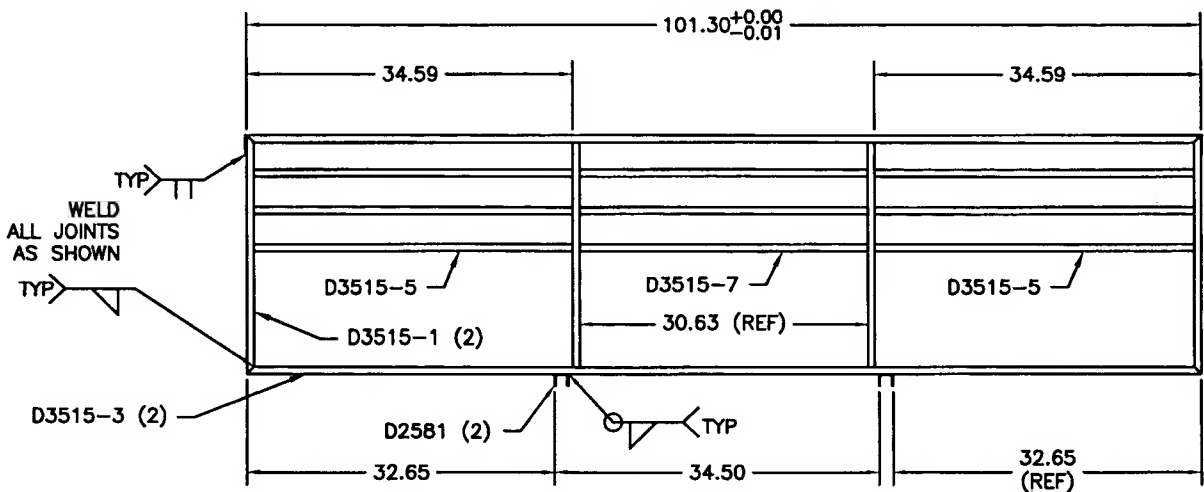
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WORK ORDER
31748 A

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DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

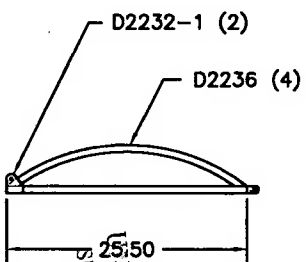
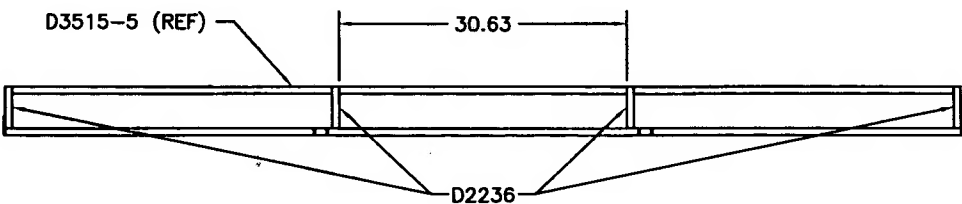


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CHECKED	APPROVED	DRAWING NO. D3515	SHEET 3 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20	



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

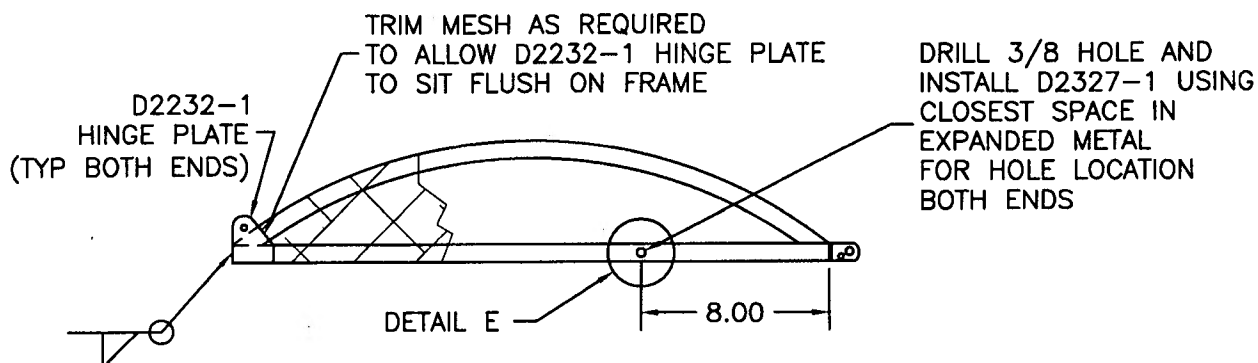


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06.11.07

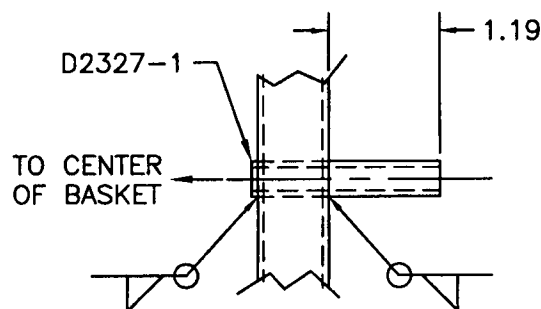


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

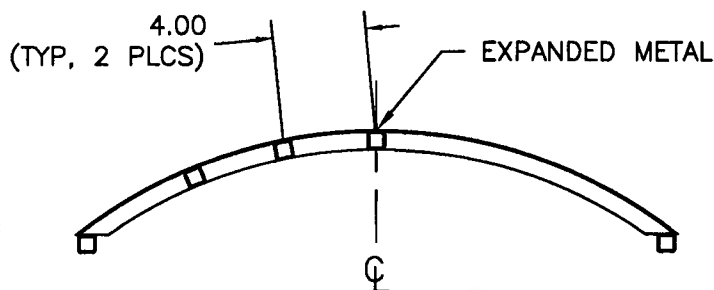


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06.11.17 *[Signature]*



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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